



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6210G02631-8G-6

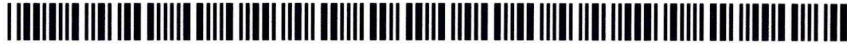
Job Sheet 186349



Part No: RBW6210G02631-8G-6

Job Qty: 5 ea

Part Name: Stiffener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6210G02631-8G Rev.B IPP Rev. A 18.10.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		11/30/18	0.00	0.00	Start Up Machining-4		DS 18-12-27
120	Mori Seiki	5 pcs		11/30/18	0.00	0.63	MORI NV5000-2		DS 18-12-27
130	QC	5 pcs		11/30/18	0.00	0.00	QC2 Machining-5		DS 18-12-27
140	QC	5 pcs		11/30/18	0.00	0.00	QC8 Machining-5		Kk 19-01-08
150	Packaging	5 pcs		11/30/18	0.00	0.00	Packaging3-2		WARD-03 DS 18-12-27
160	QC21-SA	5 Ea		11/30/18	0.00	0.00	QC21		21 JAN 10 2019

Part Op 120 - ***Cut blanks to 6.50 *** BLANK MAKES 6 PARTS 1-Machine as per folio FC 539 FOLIO REV:
Descriptions: AA DWG REV: B 2-Deburr

150 - IDENTIFY AND STOCK

* Cut blank at 2.37" Long FK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.625X02.000	6061T6 Bar 0.625 X 2.000 0.750 x 0.750	2.7150 ft (543 ea) 0.189 ea.	90-Start up Operation	5006787-19/10/18 5080899-19/10/18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.625X02.000	3	10	0

Part Specifications

Specifications could not be found.

Plex 11/14/18 12:38 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

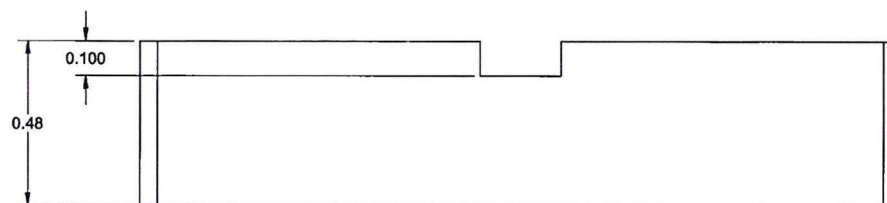
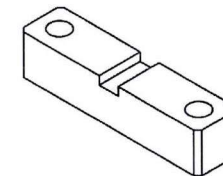
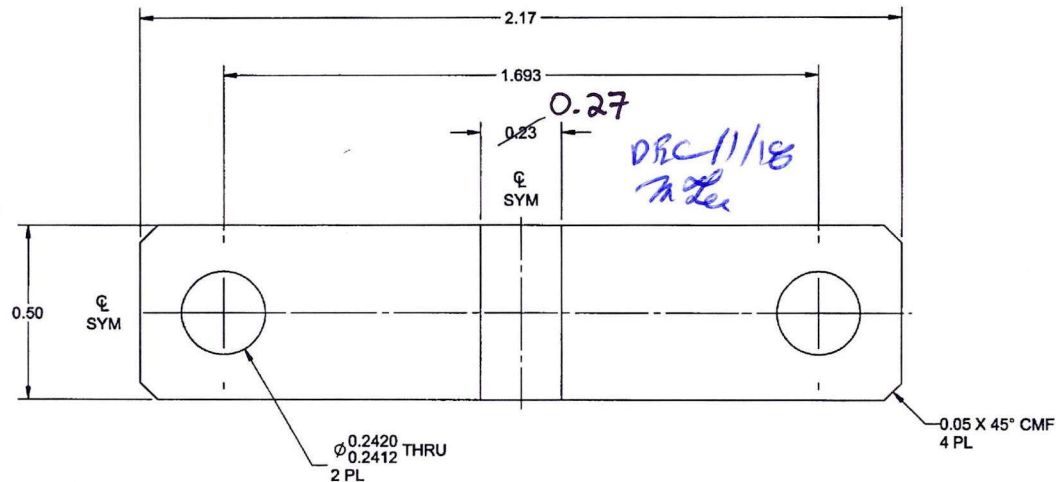
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																	
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																		
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Root Cause <table style="width:100%; border: none;"> <tr><td>Environment</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td></tr> </table> Container No: S140487 Part: RBW6210G02631 - 8G-6 Job No: 186349 Serial No/Batch: S140487 Revision: B Inspector: Exp Date: Instructions: Date: 12/27/18								Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval									
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 186349405

18-11-14



RBW6210G02631-8G-6 STIFFENER

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBW6210G02631-8G	SHEET 7 OF 10
APPROVED	VN	TITLE	SCALE
DATE 9/25/2018		M/R BLADE TRIM TAB BENDING GAUGE	NTS
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